

Work Order ID 69910

Tuesday, May 24, 2011 1:00:45 PM

Page 1

Item ID: D2724-041

Accept



Setup Start



Revision ID:

Item Name: 206L Step Assembly

Stop



Start Date: 5/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: PDate: 11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding11-06-03 2 0

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by
Jig
DT (One End Only)
A/R AL ROD Batch: 114703
Grind end cap welds flush 11592811-06-03 2 0

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 69910



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Item ID: D2724-041 Accept  Setup Start 
Revision ID:
Item Name: 206L Step Assembly Stop 
Start Date: 5/24/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 2.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120  QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds Memo | 0.00 0.00 | | | | 2 | 0 | BE11/06/07 | |
| 130  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 140  HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | | | | |

Swl06/02

h/A.E 11.06.07

x2 LH

2 0

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69910

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|----------------|--------------------|------------|------|-------|---------------|--|
| Item ID: | D2724-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | 206L Step Assembly | | | | | |
| Start Date: | 5/24/2011 | Start Qty: | 2.00 | | Cust Item ID: | |
| Required Date: | 5/31/2011 | Req'd Qty: | 2.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|---|--------------|----------------------|---------------|------------------|----------------|
| 150 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | <i>11.06.08</i> <i>Suloblor</i> | | <i>2</i> | <i>0</i> | | |
| 160 Large Fab Large Fab | Large Fab Memo Inspect for foreign object per QSI 024 Weld Remainig end cap as per Dwg D2724 using Jig DT8884 followed by Jig DT A/R AL ROD Batch: <i>M#14703</i> Grind per dwg D2724 | 0.00 0.00 | | <i>11.06.08</i> <i>A.E 11.06.09 (2)</i> <i>11.06.09</i> | | <i>2</i> | <i>0</i> | | |
| 170 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | <i>Suloblor</i> | | <i>2</i> <i>4</i> | | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69910

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|----------------|--------------------|------------|------------|-------|---------------|-------|
| Item ID: | D2724-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | 206L Step Assembly | | | | | |
| Start Date: | 5/24/2011 | Start Qty: | 2.00 | | Cust Item ID: | |
| Required Date: | 5/31/2011 | Req'd Qty: | 2.00 | | Customer: | |
| Reference: | | | | | | |
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop |
| | | | | | | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 180 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | S 406109 | | (+2) 47 | | | |
| 190 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 2X LH | | | MP 11/06/09 |
| 200 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo | 0.00 | | | | 2X LH | | | MP 11/06/10 |
| | START TIME: 10:20 OVEN TEMPERATURE: 320 OF FINISH TIME: 10:50 | | | | | | | | |

M116964

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69910

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Item ID: D2724-041

Accept

Revision ID:

Item Name: 206L Step Assembly

Start Date: 5/24/2011 Start Qty: 2.00

Required Date: 5/31/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BL 11-6-13

220

Wing Walk as per dwg QSI005 4.4 Batch 117863 0.00

HandFinish

Memo

0.00

Hand Finishing

2 HA BL 11-6-13

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 HA BL 11-6-13

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 69910

Tuesday, May 24, 2011 1:00:45 PM



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|----------------|--------------------|------------|------------|-------|---------------|-------|
| Item ID: | D2724-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | 206L Step Assembly | | | | | |
| Start Date: | 5/24/2011 | Start Qty: | 2.00 | | Cust Item ID: | |
| Required Date: | 5/31/2011 | Req'd Qty: | 2.00 | | Customer: | |
| Reference: | | | | | | |
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop |
| | | | | | | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 240 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | 69908 | | 246/14 | | 20 | |
| Packaging | | | | | | | | | |
| 250 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

11/6/14
ME
11-06-14

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 1:00:53 PM

Page 1

Work Order ID: 69910

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2622-120C

Manufactured

No

100

Each

64.0000

1

2



Step Extrusion



11.06.03

Location

Loc Qty

Loc Code

HALL

6

64409

6

WA

58

46910

2

66970

56

2

D2734

Manufactured

No

110

Each

68.0000

1

2



Step End Plate



11.06.03

Location

Loc Qty

Loc Code

WA

45

69537

45

WA015

23

66143

23

2

D3458-1

Manufactured

No

110

Each

31.0000

2

4



Step Mounting Plate



11.06.03

Location

Loc Qty

Loc Code

WA018

31

63075

31

4

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 1:00:53 PM

Page 2

Work Order ID: 69910



Parent Item: D2724-041



Parent Item Name: 206L Step Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

D3458-3

Manufactured No

110

Each

38.0000

2

4



Step Mounting Plate



11.06.03

Location

Loc Qty

Loc Code

WA018

38

63076

38

D2734

Manufactured No

160

Each

68.0000

1

2



Step End Plate



11.06.08

Location

Loc Qty

Loc Code

WA

45

69537

45

WA015

23

66143

23

2

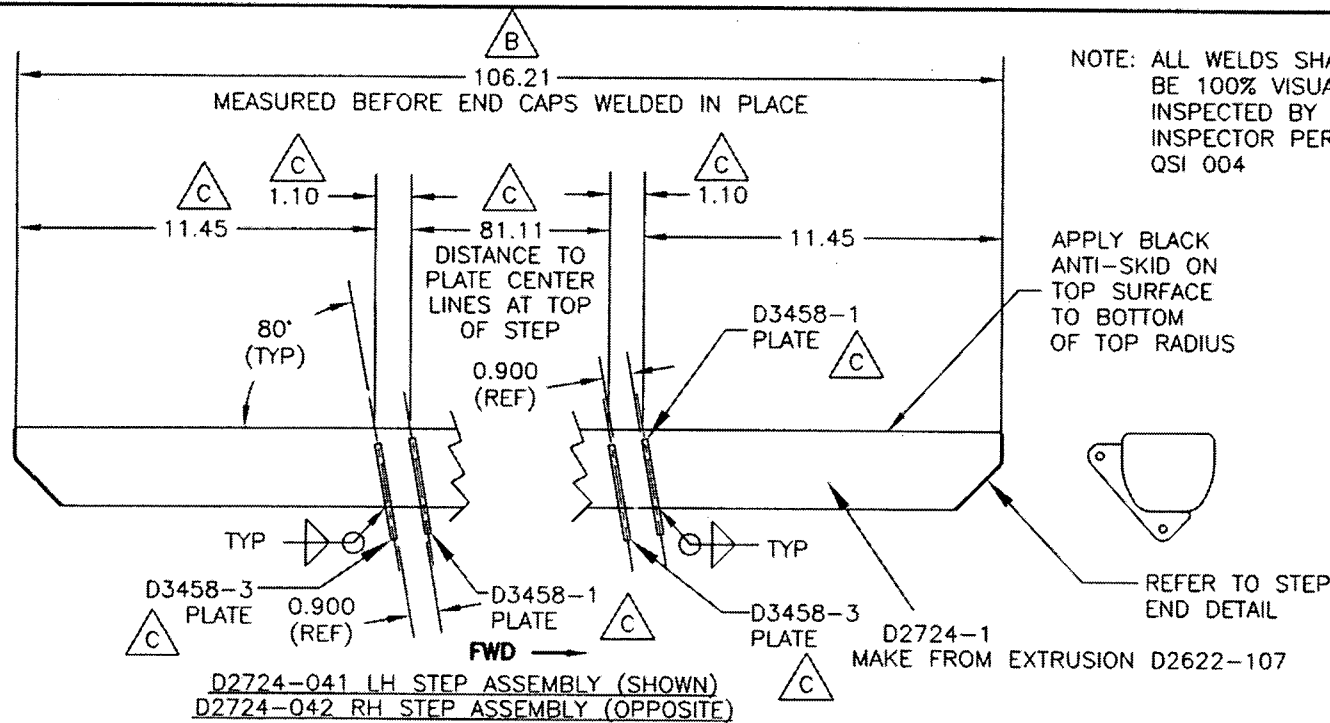
| W/O: | | WORK ORDER CHANGES | | | | | | |
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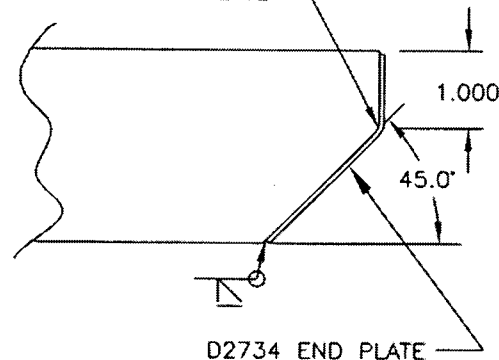
D2721-041/-042 STEP ASSEMBLY PARTS LIST

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|----------|----------|-------------|------------------|
| X | | D2724-041 | LH STEP ASSEMBLY |
| | X | D2724-042 | RH STEP ASSEMBLY |
| 1 | 1 | D2622-107 | EXTRUSION |
| 2 | 2 | D2734 | END PLATE |
| 2 | 2 | D3458-1 | PLATE |
| 2 | 2 | D3458-3 | PLATE |

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

RELEASED
05.11.14

UNCONTROLLED COPY
SUBJECT TO WORK ORDER
NO. 69910

| DESIGN | KE | DRAWN BY | PH | DART AEROSPACE USA, INC. |
|---------|----------|--------------|------------------------|---------------------------|
| CHECKED | | APPROVED | | PORT HADLOCK, WA |
| DATE | 05.09.19 | DATE | 05.09.19 | RE-DESIGN, ADD D3458-1/-3 |
| | | TITLE | 206L/407 STEP ASSEMBLY | |
| | | DRAWING NO. | D2724 | |
| | | REV. C | | |
| | | SHEET 1 OF 1 | | |
| | | SCALE | NTS | |
| | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
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